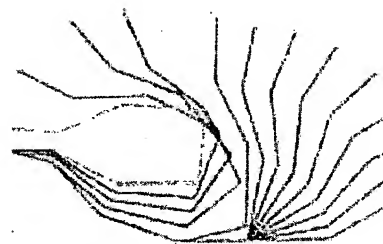


Form Process Engineering, Inc.



The Rollforming Process

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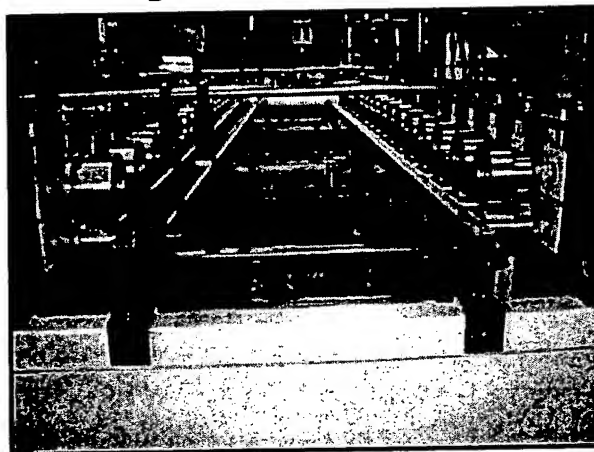
Form Process
Engineering

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7722 Georgia Road
Birmingham, AL 35212



A Complete Rollforming system with shape being formed for a greenhouse support in Form Process Engineering's roll forming operations center.



Above a Roll Former Without Roller Dies In Place

Roll Forming is a system of Sheet Metal Forming. A flat sheet of metal is drawn through a successive series of Rollers, which shape the metal as it passes through them.



The rolls (left) are known as **roller dies** and are prepared for each job. The above system has 14 **roll stations**. Each station might have a unique roller die, which progressively shapes the metal as it is drawn between the rollers. This allows for the forming of the metal into profiles. Of course the shapes are basically straight profiles. Sometimes symmetrical, sometimes not necessarily.

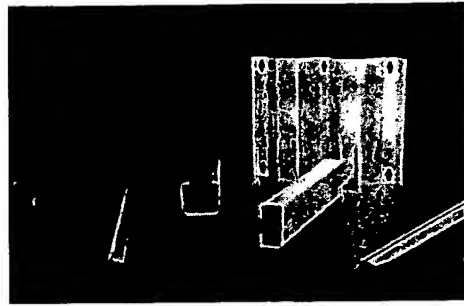


The part on left is a good example of a symmetrical **roll form**. Successive rolling through the roller dies allows for profiles that are open. These profiles have enormous application in manufacturing, building, aerospace and other applications. Parts can be fabricated from aluminum through 6 gauge steel (1/2" thick). They are rigid, with high strength.

Additional operations can **"pre-punch"** holes in precise locations for mounting to reduce weight of the final shape. **"Notching"** is another operation that punches through or punches part of the metal out from the surface.



Shapes can be cut to precise length after they are done "rollforming" part of the system with a **"Flying Cut-Off"**. "Cut-Off" allows for cutting, while the system is still moving metal through the roller dies, increasing throughput.



Examples of Rollformed Parts

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